

Work Order ID 160949

Friday, May 05, 2017 10:21:17 AM

160949

Page 1

Item ID: PB67-43001-229W

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Outer Tube Weldment

Start Date: 5/9/2017 Start Qty: 7.00

7

Cust Item ID:

Required Date: 5/17/2017 Req'd Qty: 7.00

7

Customer:

Reference: SCHEDULED/U

Approvals: Process Plan:

DAS
21
9-89

Date: MAY 05 2017 Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
B67-43001-229	DE 17/05/05								
100	BAND SAW	0.00							DAS 13 9-89
100									
Bandsaw	Memo	0.54							
Jeaspa Bandsaw	1- Cut to length and cut angle on one end of tube as per dwg 2- Deburr								
20- punch	issue pro metro as pending								
110	CONVENTIONAL MILLING MACHINE	0.00							
110									
Mill Conv	Memo	6.45							
Conventional Milling Machine	1- Drill holes and mill slot as per dwg PB67-43001 2- Deburr								
10- read	rec'd + inspect attached c of c + o w/o								
120	QC Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							
Quality Control									

JUN 07 2017

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Page 2

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Large Fab Large Fab	Weld per dwg A/R Aluminum rod Batch: 131562 Large Fab Memo 1-Weld end cap as per dwg PB67-43001	0.00 0.00				7		JUN 08 2017	DAS 24 9-89
140 *140* QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00				①	17-06-12		DAS 9 9-89
150 *150* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				①	17-06-12		DAS 9 9-89

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Item ID: PB67-43001-229W

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N900040100

Setup Start

NS1

Revision ID:

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Item Name: Outer Tube Weldment

Start Date: 5/9/2017 Start Qty: 7.00

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Cust Item ID:

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7

Customer:

Reference: SCHEDULED/U

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: <u>7</u>	0.00				<u>7</u>			DAS 24 9-89
160									
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

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9-89

JUN 13 2017

17/6/13 JD

Picklist Print

Friday, May 05, 2017 10:21:17 AM

Page 1

Work Order ID: 160949

160949

Parent Item: PB67-43001-229W

PR67-43001-229W

Parent Item Name: Outer Tube Weldment

Start Date: 5/9/2017

Required Date: 5/17/2017

Start Qty: 7.00

Required Qty: 7.00

Comments: IPP REV:A 15.04.02 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T1.750W.065		Purchased	No			100	f	50.3690	5.125	37.76316			DAS 13 9-89
M6061T6T1 750W 065									**			MAY 23 2017	
6061T6 RDTUBE 1.750 X 0.65W													

Location

Loc Qty

Loc Code

MAT016

50.369

M133700

7.681

M136283

42.688

PB67-43001-233

Manufactured

No

130

Each

4.0000

1

7

JUN 08 2017

DAS
24
9-89

PR67-43001-233

Outer Tube End Cap

Location

Loc Qty

Loc Code

Mezz

4

105777

4

B 160959 → 3

4

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

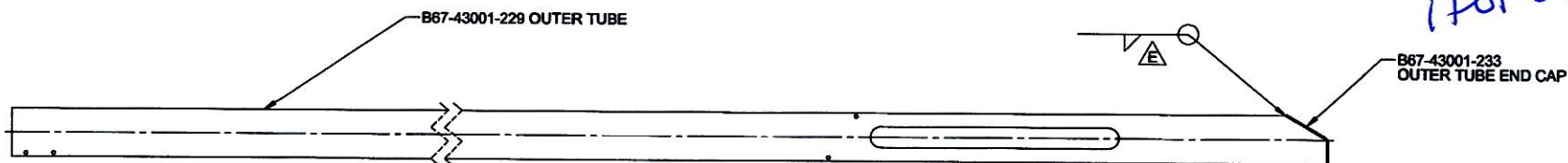
Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
103 20 Jul								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
OTHER : ☐									

INSPECTION SHEET

Rev	Date	Change	Revised by	Approved
A	09.10.22	New Issue	KJ	
B	15.06.23	Dwg Rev updated	KJ	
C	17.01.31	Dwg Rev updated	KJ	

ITEM	QTY	P/N	DESCRIPTION
	X	B67-43001-229W	OUTER TUBE WELDMENT
1	1	B67-43001-229	OUTER TUBE
2	1	B67-43001-233	OUTER TUBE END CAP

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 160949 *MUS*
170505



B67-43001-229W OUTER TUBE WELDMENT

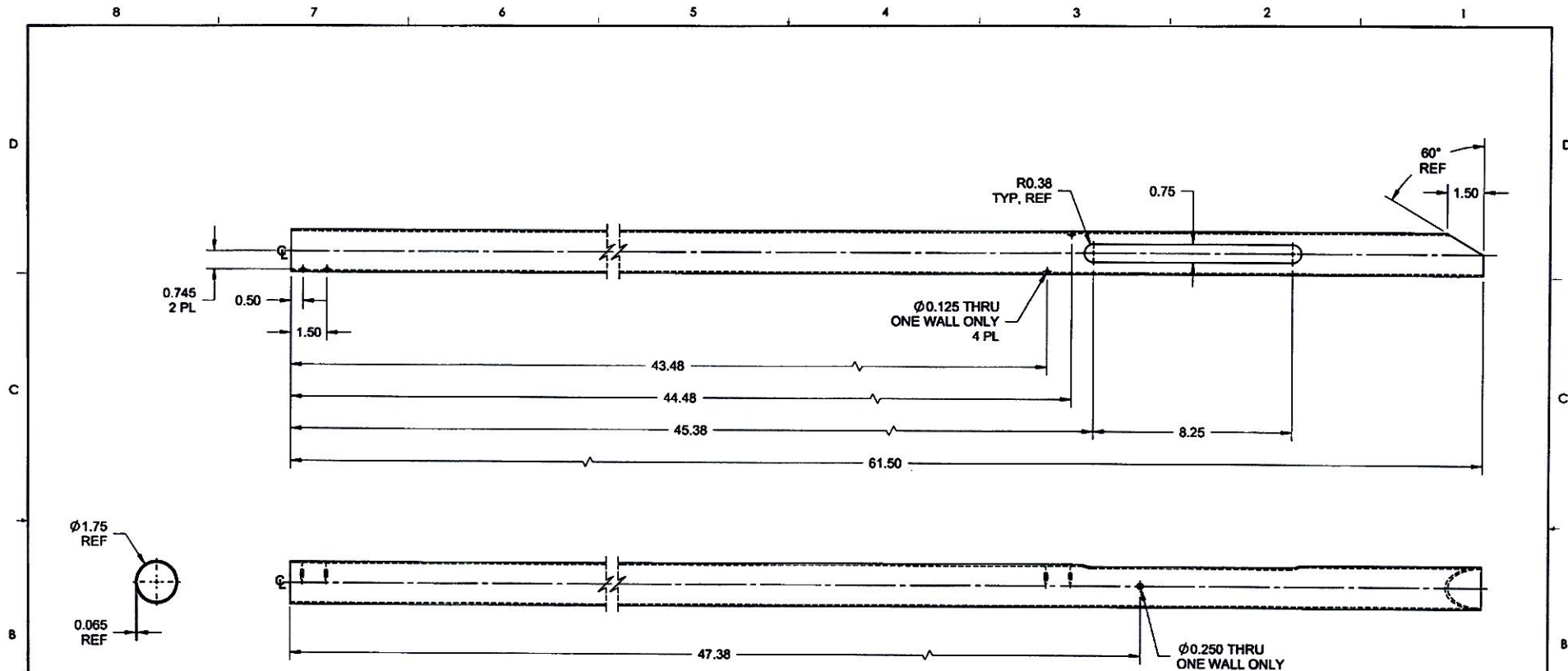
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.02 lbs
- 8) WELDING: PER DART QSI 004

E	CHANGE GRINDING NOTE ON OUTER TUBE END CAP WELD, UPDATE MATL SPECIFICATION, REASON PAR15-437	SAD	18.10.14
D	ADD -229W WELDMENT, MOVE HOLE LOCATION (ZN C7-2) REASON: TO FACILITATE MANUFACTURING	DB	14.07.22
C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 19 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.	MB	09.02.27
REV.	DESCRIPTION	BY	DATE
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. B67-43001-229 TITLE OUTER TUBE COPYRIGHT © 1985 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DRAWN	SAD		
CHECKED	MB		
MFG. APPR.	DD		
APPROVED	WM		
DE APPR.	N/A	REV. E SHEET 1 OF 2 SCALE NTS	
DATE	16.10.14		

RELEASED
2016-11-09
Cw 11-655

APPROVED



B67-43001-229 OUTER TUBE

NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62/T6510/6511 ALUMINUM SEAMLESS TUBING
PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR
AMS 4083 OR AMS-QQ-A-200/8 OR AMS-QQ-A-225/8
OR ASTM B210 OR ASTM B241
REF. DART SPEC. M6061T6T1.750W.065
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.00 lbs

RELEASED
2016-11-09

APPROVED

DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SAD		
CHECKED	MB	DRAWING NO.	REV. E
MFG. APPR.	DD	B67-43001-229	SHEET 2 OF 2
APPROVED	WM	TITLE	SCALE
DE APPR.	N/A	OUTER TUBE	NTS
DATE	16.10.14	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PROVIDED AND CONVEYED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO36405**

Purchase Order Date 5/23/2017

PO Print Date 6/5/2017

Page Number 4 of 5

Order From :

VC-MET003

Ship To : DART AEROSPACE LTD

METEC METAL TECHNOLOGY INC.
20 TERRY FOX DRIVE PO BOX 781
VANKLEEK HILL, ON K0B 1R0
CA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 613 678 3957

Ship To Contact

Ship To Phone

Ship Via: Dart Truck

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 10

Currency

CAD

FOB

Destination-Collect

Line Total: \$0.00

9 160949 PB67-43001-229 OUTER 6/16/2017

TUBE

Yes

6/16/2017

MACHINE AS PER DWG PB67-43001-229
MATERIAL 6061-T6 ROUND TUBING 1.750" X 0.065" WALL M137541

Line Total: \$0.00

10 160930 PB67-43001-235 OUTER 6/16/2017

TUBE

Yes

6/16/2017

MACHINE AS PER DWG PB67-43001-235
MATERIAL 6061-T6 ROUND TUBING 1.750" X 0.065" WALL M137541

Line Total: \$0.00

Note:

6/5/2017



20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0 , Canada
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.: 21723
Date: Jun 06, 2017
Page: 1

Sold to:	Ship to:
Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: 36405	Sold By: Walz, Christian D.
Shipped By: your truck	Ship Date: Jun 06, 2017

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D5159-3 Seat Rib, as per drawing D5159-3 Rev. A	Each	6	6	
PB67-43001-127 Handle Arm, as per drawing PB67-43001-127	Each	5		
PB67-43001-257 Inner Tube, as per drawing PB67-43001-257	Each	7		
PB67-43001-247 Inner Tube, as per drawing PB67-43001-247	Each	6		
PB67-43001-255 Inner Tube, as per drawing PB67-43001-255	Each	7		
PB67-43001-259 Inner Tube, as per drawing PB67-43001-259	Each	7		
PB67-43001-285 Upper Tube, as per drawing PB67-43001-285 *** please note that 1 piece has an extra hole in wrong position (marked red) ***	Each	5	5	
PB67-43001-197 Outer Tube, as per drawing PB67-43001-197	Each	7	7	
PB67-43001-229 Outer Tube, as per drawing PB67-43001-229	Each	7	7	
PB67-43001-235 Outer Tube, as per drawing PB67-43001-235	Each	7	7	
The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.				
Received by <u>SP17-6-7</u>		Thank you for your order!		

DAS
38
9-89



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0
Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

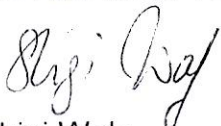
same

Quantity	Part Number	Part Name	Material & Batch #	P.O. Number
6	D5159-3	Seat Rib	SS304 square tubing 0.750" x .049" wall M137401	36405
5	PB67-43001-285	Upper Tube	6061-T6 round tubing 1.500" x .125" wall M133966, M135028	36405
7	PB67-43001-197	Outer Tube	6061-T6 round tubing 1.750" x 0.065" wall M137541	36405
7	✓ PB67-43001-229 ✓	Outer Tube	6061-T6 round tubing 1.750" x 0.065" wall M137541	36405
7	PB67-43001-235	Outer Tube	6061-T6 round tubing 1.750" x 0.065" wall M137541	36405

MATERIAL: supplied by DART

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.


Shigi Walz

Vankleek Hill, June 6, 2017